

Work Order ID 79467

79467

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Item ID: D2066 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 26/01/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/26 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2066	Rev C

100 0.00
100 Small Fab *cut at 28.88* *5* *FF* *12-02-03*
 Small Fab Memo 0.00
 Small Fab 1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube*
 (Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
 Use punch Jig DT8012
 2-Slide on parts per Dwg and W/O for D2676-043
 3-Punch other end to length (28.62") as per Dwg D2066
 4-Bend per Dwg D2066
 5-Drill using DT9034

110 0.00
110 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control *51762103* *(5)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D2066

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 26/01/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location St

0.00

120

Packaging

Memo

0.00

Packaging

(5x) SP 12-02-06

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/02/06 HF12-02-06
(5)

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Picklist Print

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Work Order ID: 79467

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP D 02.03.18 Added pick list NG
IPP E 07.10.03 removed p/c EC verified by: DD
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10. *AN960.ID10* Washer	NAS1149D0363J	Purchased	No	M120142 (202)		100	Each	0.0000	4	20			
									**			FF 12-02-03	
D2052 *D2052* Mounting Bracket		Manufactured	No			100	Each	13.0000	2	10			
									**			FF 12-02-03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		13				10			
				73052		13							
D2054 *D2054* Bushing		Manufactured	No			100	Each	22.0000	2	10			
									**			FF 12-02-03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		22				10			
				67784		22							
D2055 *D2055* Clamp		Manufactured	No			100	Each	9.0000	1	5			
									**			FF 12-02-03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		9				5			
				71890		9							

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2056

Manufactured No

100

Each

22.0000

1

5

D2056

Bell Crank

**

FF 12-02-03

Location

Loc Qty

Loc Code

GA

22

71102

2

71889

20

2

3

MS21042L3

Purchased

No

100

Each

5,434.000

2

10

MS21042L3

Nut

**

FF 12-02-03

Location

Loc Qty

Loc Code

ST300

5434

117441

16

117885

32

118451

5

118927

3

119017

4958

119075

420

10

MS27039-1-18

Purchased

No

100

Each

81.0000

2

10

MS27039-1-18

Screw

**

FF 12-02-03

Location

Loc Qty

Loc Code

ST291

81

115589

56

120308

25

10

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D2066

Parent Item Name: Arm

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 5.00

Required Qty: 5.00

M304TR0.500W.049

Purchased

No

120

f

194.3131

2.386

12.55789

M304TR0 500W 049

304 RD Tube .500 x .049W

**

FF 12-02-03

Location

Loc Qty

Loc Code

MAT017

194.313058

111814

2.23

115010

109.254058

117598

42.57

119087

40.259

1
3.4
9.6
12.0

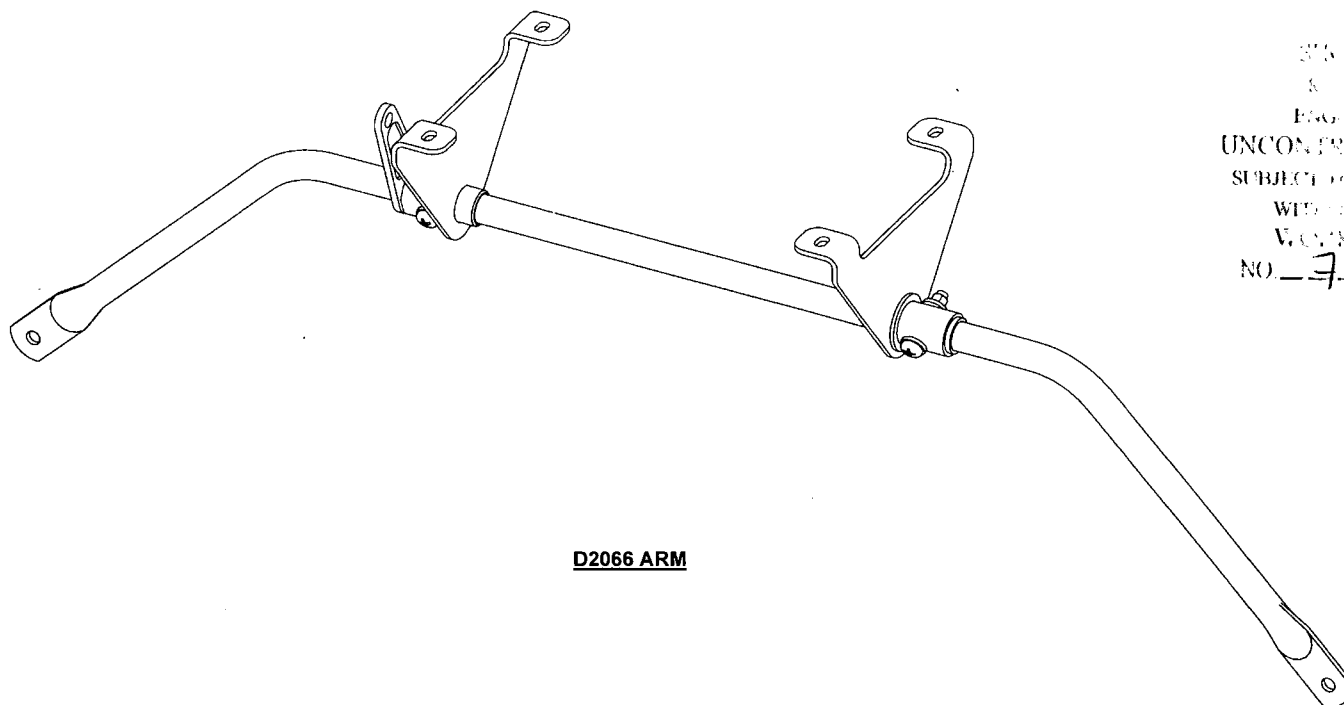
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D2066 ARM

STANDARD COPY
 UNCONTROLLED COPY
 SUBJECT TO REVISION
 WITH NO
 WORK IN PROGRESS

NO. 79467 M.L.J

12/01/26

RELEASED
 08-07-13-10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PL		
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.	h	D2066	SHEET 1 OF 2
APPROVED	h	TITLE	SCALE
DE APPR.	h	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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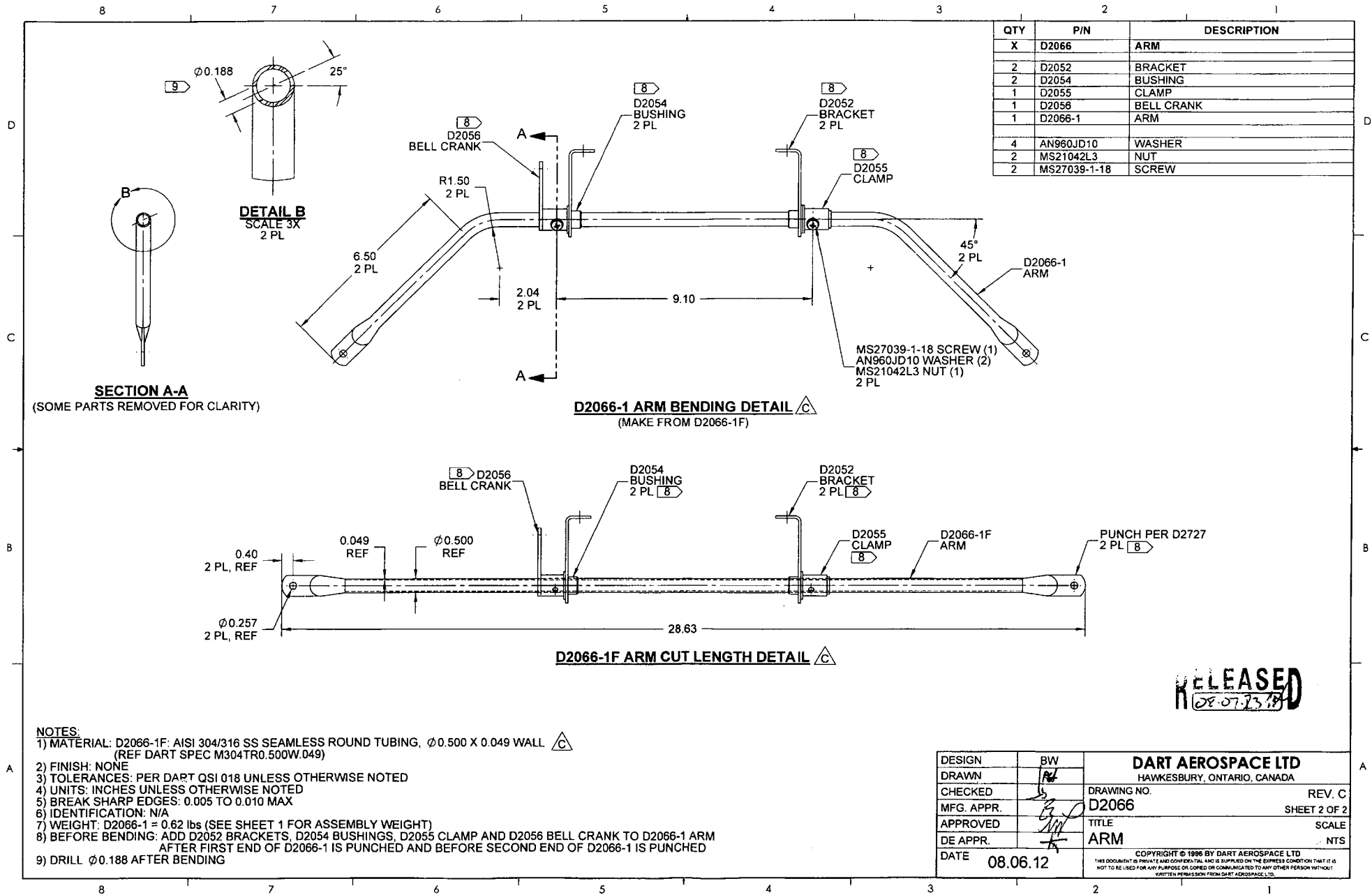
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